



WORK ORDER 2007-21

Date opened: 29 November 2007

Project: High Mounted Quick Release Cargo Basket Assembly
Type: Bell 206L Series, 407

Batch Quantity: 3 Complete Basket Assemblies (76610-01)
All with Auxiliary Latch Installation (70403)

Approval: SH00-48
Drawing List: DCL766-2


Fabrication and Assembly Drawing(s)	Description
76610, Rev. 0	Basket Ass'y
76611, Rev. 0	Basket Body Ass'y
60632, Rev. 0	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 1	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
70403, Rev. 0	Auxiliary Latch Installation

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y ✓</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y ✓</u>
Drawings revision levels match Document Control List:	<u>Y ✓</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y ✓</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y ✓</u>
Release tags associated with all fabricated parts are attached:	<u>Y ✓</u>
All mounting hardware and supplies are included:	<u>Y ✓</u>

List all non-conformities raised: _____


Inspector Signature: _____ Date: May 22/08.

Drawing: 76610 Revision 0
 Assembly: 76610-01 Cargo Basket Ass'y (Quick-Release, High Mounted)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76610-01	Cargo Basket Assembly			
1	76611-01	Basket Body Assembly	Below		
1	60632-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	7005	
1	MS20001P4	Piano Hinge		6067	
1	76625-01	Placard	0.063" Sheet, 6061-T6 Aluminum	960708	
3	49205-14	Bumper	Argus Industries Bumper	6038	
A/R	CR3213-4-02	Cherry Rivet		7010	
4	40088-14	Fitting	Ancra	6058	
4	AN960-616	Washer		6016	
1	AN3-15A	Bolt		6016	
1	AN3-17A	Bolt		6066	
4	AN960-10	Washer		6043	
2	AN970-3	Washer		5026	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		<i>Jeff Chalk</i>
Final Inspection	Drawing 76610			<i>Jeff Chalk</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 76611 Revision 1
 Assembly: 76611-01 Basket Body Ass'y (High Mounted Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76611-01	Basket Body Assembly			
1	76621-01	End Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
4	76623-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
1	76622-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
5	60643-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	951108	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 76611			
Final Inspection	Drawing 76611			

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Drawing: 60632 Revision 0
 Assembly: 60632-01 Basket Lid Ass'y (High Mounted Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	60632-01	Basket Lid Assembly			
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
4	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	951108	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9516042	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	
6	60649-01	Step Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
A/R	60632-10	Tread Plate	3003 Aluminum, 0.063 tread sheet	7058	

Processes	Per	Mat'l's Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		<i>Jeff Clarke</i>
Powder Coat	Drawing 60632			<i>Jeff Clarke</i>
Final Inspection	Drawing 60632			<i>Jeff Clarke</i>

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	7004	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		6043	
2	MS21044N3	Nut		6016	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			<i>Jff Chk.</i>

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	6006	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2005	
2	MS20615-4M3	Rivet		7039	

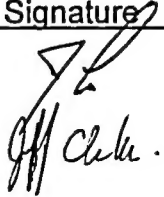
Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	6003	

Processes	Per	Mat'l's Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			

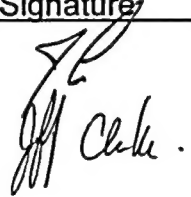
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Drawing: 70403 Revision 0
Assembly: 70403-01 Auxiliary Latch Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	70403-01	Auxiliary Latch Modification			
2	60650-04	Tab	321 Stainless Steel, 0.032 Sheet	3021	
2	60650-05	Insert	1018 Steel, 0.375 Rod	951108	
1	60650-06	Bushing	Brass, 0.25 Rod	7047	
1	0115-306	Latch Cord	Arctic Cat	7002	
1	0115-307	Latch Cup	Arctic Cat	7002	
1	AN3-10A	Bolt		6071	
2	AN960-10	Washer		6016	
1	MS21044N3	Nut		6016	
2		#8-32 Screw	Stainless steel, commercial		

Note: Remainder of assembly listed on drawing 76611 and 60632

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70403			

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AERO DESIGN LTD.

2013 – 39th Ave N. E., Calgary, Alberta, T2E 6R7

www.aerodesign.ca

F A X C O V E R S H E E T

DATE: November 24, 2008
TO: Mark Thurston
Northern Air Support

TIME: 11:35 AM
PHONE: 250-765-0100
FAX: 250-765-0273

FROM: J. Clarke
Aero Design Ltd.

PHONE: 403-250-8027
FAX: 403-250-8333

Number of pages including cover sheet: 2

RE: RELEASE TAGS FOR CARGO BASKET

Mark,

Please find attached the release tags for the High Mounted Quick Release Cargo Basket and Beams.

Let me know if you need anything further.

Regards,


Jeff

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-01

WO #: 2007-21 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

Remarks: With Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Jan 30/08

Jeff Clark

Ins 's SI nature

Northern
AIR
SUPPORT.

V1H
AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-02

WO #: 2007-21 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

Remarks: With Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

May 22/08
Date

[Signature]
Insp's Signature

V14
AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 76610-01
Approval #: SH00-48 Serial #: 76601-03
WO #: 2007-21 Quantity: 1
Eligibility: Bell 206L / 407 Work Status: Manufactured
Remarks: With Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

May 22/08
Date

[Signature]
Ins e Si nature